

Work Order ID 140599

January 08, 2016 8:35:38 AM

140599

AOG ship today

Page 1

Item ID: D407-558-045

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Single Mirror Installation

Start Date: 1/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SA Date: 0160108

Tooling:

Date:

Run Start

NR1

QC: Date:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN 206-558	REV D

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D407-558-045 CHG003

1

DAS
28
9-89

JAN 08 2016

110

0.00

110

Small Fab

Small Fab

Memo

0.01

Small Fab

Assemble as per Dwg D206-558

1

FF

JAN 08 2016

JAN 08 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(1)

DAS
38
9-89

JAN 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Work Order ID 140599

January 08, 2016 8:35:38 AM

140599

Page 2

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Revision ID:

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Item Name: Single Mirror Installation

Start Date: 1/8/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

125

Pick Kit

0.00

125

Packaging

Memo

0.00

Packaging

DAS
28
9-89

JAN 08 2016

DAS
28
9-89

130

QC4- 100% Inspect kits for completeness

0.00

130

QC

Memo

0.00

Quality Control

DAS
28
9-89

JAN 08 2016

140

Packaging

0.00

140

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per RPP D407-558-045
LOCATION: FG011DAS
28
9-89

JAN 08 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 140599***140599***

Page 3

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Run Start ***NR1***

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Stop ***NR2***

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

150

QC Memo

0.00

Quality Control

MLJ JAN 08 2016MLJ JAN 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

January 08, 2016 8:35:48 AM

Page 1

Work Order ID: 140599

140599

Parent Item: D407-558-045

D407-558-045

Parent Item Name: Single Mirror Installation

Start Date: 1/8/2016

Required Date: 1/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-15 new issue DD verified by:ec IPP Rev:B
10.06.17 added grommet DD verf:EC IPP REV:C 11.01.19 AS
PER chg002 DD VERF:EC IPP REV:D 12.04.04 AS PER
chg003 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS35489-67 *MS35489-67* GROMMET		Purchased	No				Each	55.0000		1			
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>					DAS 6 9-89
				ST274				55					
				121600				55					
MS35489-9 *MS35489-9* Grommet		Purchased	No				Each	11.0000		1			
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>				JAN 0 8 2016	DAS 6 9-89
				ST270				11					
				m132262				11					
D2011-101 *D2011-101* Mirror 6"		Manufactured	No			110	Each	3.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>				JAN 0 8 2016	
				FG				2					
				106348				2					
				ST384				1					
				135152				1					

DAS
26
9-89

DAS
26
9-89

FF

Picklist Print

January 08, 2016 8:35:49 AM

Page 2

Work Order ID: 140599

140599

Parent Item: D407-558-045

D407-558-045

Parent Item Name: Single Mirror Installation

Start Date: 1/8/2016

Required Date: 1/8/2016

Start Qty: 1.00

Required Qty: 1.00

~~D2052~~

Manufactured No

110

Each

15.0000

2

2

D2052

Bracket

FF

JAN 0 8 2016

Location

Loc Qty

Loc Code

GA

15

108808

15

2

Manufactured No

110

Each

29.0000

2

2

D2054

Bushing - Delrin

FF

JAN 0 8 2016

Location

Loc Qty

Loc Code

GA

29

109091

29

2

Manufactured No

110

Each

24.0000

1

1

D2055

Clamp

FF

JAN 0 8 2016

Location

Loc Qty

Loc Code

GA

24

105730

17

1

95397

7

1

Manufactured No

110

Each

8.0000

1

1

D2056

Bell Crank Assembly

FF

JAN 0 8 2016

Location

Loc Qty

Loc Code

GA

8

109921

8

1

Picklist Print

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Page 3

Work Order ID: 140599

140599

Parent Item: D407-558-045

D407-558-045

Parent Item Name: Single Mirror Installation

Start Date: 1/8/2016

Required Date: 1/8/2016

Start Qty: 1.00

Required Qty: 1.00

D2057
D2057
Plug

Manufactured No 110 Each 14.0000 1 1

**

FF

JAN 0 8 2016

Location Loc Qty Loc Code

GA 14
112928 14

D2065
D2065
Mirror Arm

Manufactured No 110 Each 2.0000 1 1

**

FF

JAN 0 8 2016

Location Loc Qty Loc Code

ST360 2
132648 2
110 2

D3778-3
D3778-3
Bracket

Manufactured No 110 Each 6.0000 1 1

**

SL

FF

JAN 0 8 2016

DAS
28
9-89

Location Loc Qty Loc Code

ST513 6
113715 6

MS21042L3
MS21042L3
Nut

Purchased No 110 Each 1,497.000 2 2

**

FF

JAN 0 8 2016

Location Loc Qty Loc Code

FP001 183
m133790 183
GA 218
m133790 218
ST304 1096
m133790 1096

2

Picklist Print

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Page 4

Work Order ID: 140599

Parent Item: D407-558-045

Parent Item Name: Single Mirror Installation

140599

D407-558-045

Start Date: 1/8/2016

Required Date: 1/8/2016

Start Qty: 1.00

Required Qty: 1.00

~~MS27039-1-18~~

Purchased

No

110

Each

1,837.000

2

2

MS27039-1-18

Screw

FF

JAN 08 2016

Location

Loc Qty

Loc Code

GA

257

123522

57

124326

200

over006

1373

124326

1373

ST280

207

124326

207

~~NAS1149D0363J~~

Purchased

No

110

Each

1,245.000

4

4

NAS1149D0363J

Washer

FF

JAN 08 2016

Location

Loc Qty

Loc Code

GA

112

m130799

112

ST263

1133

m133709

133

m133790

500

m133932

500

AN3-4A

Purchased

No

125

Each

154.0000

4

4

AN3-4A

Bolt

JAN 08 2016

DAS
28
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

100

m133694

100

ST350

54

m129682

13

m133234

41

DAS
28
9-89

January 08, 2016 8:35:49 AM

Shop Packet Print

Page 4

Picklist Print

January 08, 2016 8:35:49 AM

Page 5

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140599

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D407-558-045

Parent Item Name: Single Mirror Installation

Start Date: 1/8/2016

Required Date: 1/8/2016

Start Qty: 1.00

Required Qty: 1.00

AN526-1032R9

Purchased

No

125

Each

75.0000

4

4

DAS
6
9-89

AN526-1032R9

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST326

75

m131139

75

125

Each

23.0000

1

1

**

D2053

Manufactured

No

D2053

Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST002

7

101704

7

ST012a

16

108842

16

125

Each

41.0000

1

1

**

D2067

Manufactured

No

D2067

Connector

DAS
28
9-89

Location

Loc Qty

Loc Code

ST002

41

105444

41

125

Each

8.0000

1

1

**

D2071-5

Manufactured

No

D2071-5

Cable

DAS
28
9-89

Location

Loc Qty

Loc Code

ST216

8

112929

8

DAS
6
9-89

JAN 08 2016

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Page 6

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Parent Item Name: Single Mirror Installation

Start Date: 1/8/2016

Required Date: 1/8/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

125

Each

1,497.000

1

1

MS21042L3

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

183

m133790

183

GA

218

m133790

218

ST304

1096

m133790

1096

MS21919-DG5

Purchased

No

125

Each

18.0000

2

2

MS21919-DG5

Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

ST297

18

m129499

18

NAS1149D0332J

Purchased

No

125

Each

1,237.000

6

6

NAS1149D0332J

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

70

m129682

70

GA

289

m132677

289

ST264

864

m133498

864

DAS
6
9-89

DAS
28
9-89

DAS
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JAN 08 2016

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052**	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054**	BUSHING
1	1	1	1	D2055**	CLAMP
1	1	1	1	D2056**	BELLCRANK ASSEMBLY
1		1		D2057	PLUG
1		1		D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-5	CABLE ASSEMBLY
1	2	1	2	D3014-1	LOCKNUT
1	1			D3778-1	BRACKET
		1	1	D3778-3	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
1	2	1	2	NAS1149D0416P*	WASHER (AN960JD416L)
4	4	4	4	NAS1149D0363P**	WASHER (AN960JD10)
6	6	6	6	NAS1149D0332P	WASHER (AN960JD10L)
3	1	3	1	MS21042-3	NUT (or MS21042L3)
	2		2	MS21042-3**	NUT (or MS21042L3)
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18**	SCREW
1	1	1	1	MS35489-9	GROMMET
1	1	1	1	MS35489-67	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

** INCLUDED AS PART OF D2066 ARM (REF. -043/-047 ONLY)